DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-022377
Date Inspected: 16-Mar-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Santa Fe Springs, CA.

CWI Name: Ruben Dominguez

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No		
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A	
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A	
				Approved WPS:	☑ Yes	☐ No	☐ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: Travelers

Summary of Items Observed:

This Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection, non-destructive testing and painting of the Travelers. Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

This QA Inspector randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

SAS-WB Traveler

This QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Jimenez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Richard Fuentes (WID # 3201) continuing to perform Flux Core Arc Welding (FCAW) tacking and fitting activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW on tube steel and plate material, randomly throughout the shift.

This QA Inspector randomly observed that Smith Emery QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

Paint: SAS and E2/E3-EB Travelers

This QA Inspector and METS representative Mr. Fintan Shanley observed that the blasting activities appeared to be in process, in an area which had been previously enclosed with tarps and metal stands had been placed for blasting the Traveler assemblies. The assemblies appeared to be 3 each elevating and 2 each platform balconies, for the SAS and E2/E3-EB Travelers. This QA Inspector observed that 2 RPI Coating production personnel appeared to be performing the blasting activities and 1 RPI Coating personnel appeared to be helping. During observation, this QA Inspector observed Mr. Shanley performed random testing on the previously blasted metal, utilizing Testex Press-O-Film and a micrometer. This QA Inspector and Mr. Shanley noted that the random testing on the blasted metal appeared to be in compliance with the contract requirements of 40um (1.57mils)-80um (3.15mils). During observation, this QA Inspector and Mr. Shanley performed random VT on the previously blasted metal and this QA Inspector observed Mr. Shanley utilizing white chalk to mark up minor areas of the metal which had been previously missed, during the blasting activities. Mr. Shanley then explained to this QA Inspector that the areas marked appear to be mill scale and not minor staining. After observation, this QA Inspector had general discussion with RPI representatives on site. During discussions, this QA Inspector and Mr. Shanley explained to RPI that minor mill scale was present in small areas and had been marked with white chalk. RPI then explained that the current blasting being performed was preliminary and a sweep blast will be performed tomorrow morning. RPI further explained that primer application will not start today and RPI appeared to understand that primer application is needed within 8 hours of the completion of sandblast to prevent minor rusting.

See attached pictures below.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

WELDING INSPECTION REPORT

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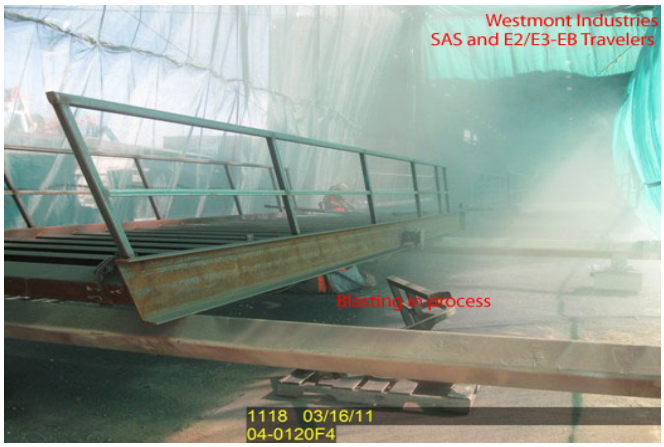

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer